

Work Order ID 120338

June-09-14 11:33:14 AM

646.3719

\*120338\*

Page 1

B120338

Item ID: 646.3719

REV-A

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Doubler

Start Date: 7/11/14 Start Qty: 40.00

30  
\*40\*

Cust Item ID:

Required Date: 7/11/14 Req'd Qty: 40.00

\*40\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

646.3700

A

105

0.00

\*105\*

Purchasing

Memo

0.00

Purchasing

ISSUE PO 24574  
CUT PER DRWG

CL 14/06/12 40

115

Receive & Inspect for Damage & Mat'l Certs

0.00

\*115\*

Packaging

Memo

0.00

Packaging

14/7/11 (30)

125

QC6- Inspect dimensions to drawing

0.00

\*125\*

QC

Memo

0.00

Quality Control

(30)

DAS  
38  
9-89

14/08/21

# Work Order ID 120338

June-09-14 11:33:14 AM

**\*120338\***

Page 2

Item ID:	646.3719	Accept	<b>*N900040100*</b>	Setup	Start	<b>*NS1*</b>
Revision ID:					Stop	<b>*NS2*</b>
Item Name:	Doubler					
Start Date:	7/11/14	Start Qty: 40.00	<b>*40*</b>	Cust Item ID:		
Required Date:	7/11/14	Req'd Qty: 40.00	<b>*40*</b>	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	<b>*NR1*</b>
	QC:	Date:	SPC (Y/N):	Date:		Stop	<b>*NR2*</b>

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Outsource process-Anodize per QSI017 4.1.10.1	0.00							
<b>*140*</b>									
Outsource4	Memo	0.00							
Outsource process - Anodize	Issue P/O to ATG : <u>25511</u>								
	1- Black Anodize as per Dwg 646.3700								
	2- PRIME AS PER DWG, SEE NOTE #2								
	Certification of Conformity is required								
150	Receive & Inspect for Damage & Mat'l Certs	0.00							
<b>*150*</b>									
Packaging	Memo	0.00							
Packaging									
160	QC5- Inspect part completeness to step on W/O	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

CL 14/08/25 30

P 7/4/12 (30)

30 DAS  
38  
9-89 14-8-2

# Work Order ID 120338

June-09-14 11:33:14 AM

**\*120338\***

Page 3

Item ID: 646.3719 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Doubler  
 Start Date: 7/11/14 Start Qty: 40.00 **\*40\*** Cust Item ID:  
 Required Date: 7/11/14 Req'd Qty: 40.00 **\*40\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: _____	0.00							
<b>*190*</b>									
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***								
200	QC21- Final Inspection - Work Order Release	0.00							
<b>*200*</b>									
QC	Memo	0.00							
Quality Control									

DAS  
32  
9-89

14/9/2 (30)

MLJ 14-09-03

MLJ 140903

# Picklist Print

June-09-14 11:33:13 AM

Page 1

Work Order ID: 120338

**\*120338\***

Parent Item: 646.3719

**\*646.3719\***

Parent Item Name: Doubler

Start Date: 7/11/14

Required Date: 7/11/14

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP REV:A 12.10.22 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.063

Purchased

No

110

sf

503.0880

0.02778

2

**\*M6061T6S.063\***

**\*\***

*CS 14/06/12*

6061-T6 .063 Sheet

Location

Loc Qty

Loc Code

MAT021

503.088

M124446

3.7

M126075

4.5

M127006

9

M127420

117.12

M128054

84.768

M128941

284

*m1291637*

*(2)*

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03702				SHEET 1 OF 2	
	DWG NO. 646.3700	REV: A	PREPARED BY B. PETERS	DATE: 11/15/12	EFFECT ON DWG <input type="checkbox"/> INC. <input checked="" type="checkbox"/> UNINC.	
	DWG TITLE: SHEETMETAL					
APPROVED BY: ENGR. <i>[Signature]</i>		MFG. <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: NEXT ORDER		
TRANSACTION CODES (TC) A-ADD C-CREATE R-REVISE D-DELETE		REASON: ADDED ALTERNATE MATERIAL AND REVISED REFERENCE DIMENSIONS			EOR: D-12-010	

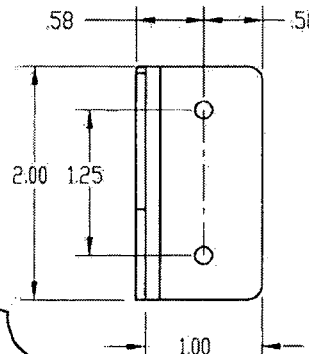
## SHEET 1, ZONE A2 IS:

IS

⚠ PRIMARY MATERIAL: ALUMINUM 6061-T6 PER AMS-QQ-A-250/11  
ALTERNATE MATERIAL: SS 17-4 PH PER AMS 5604

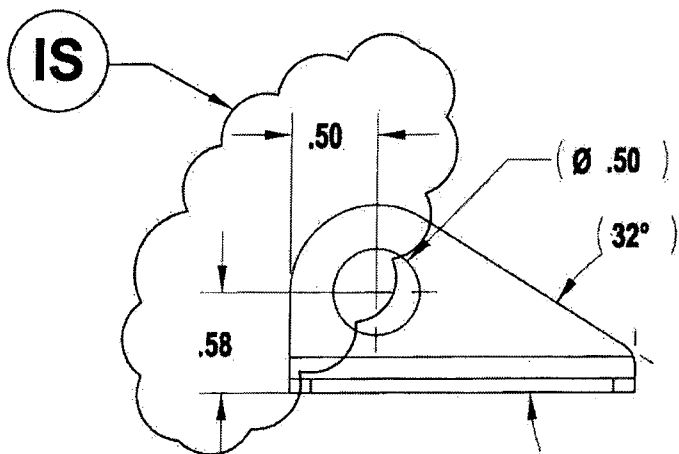
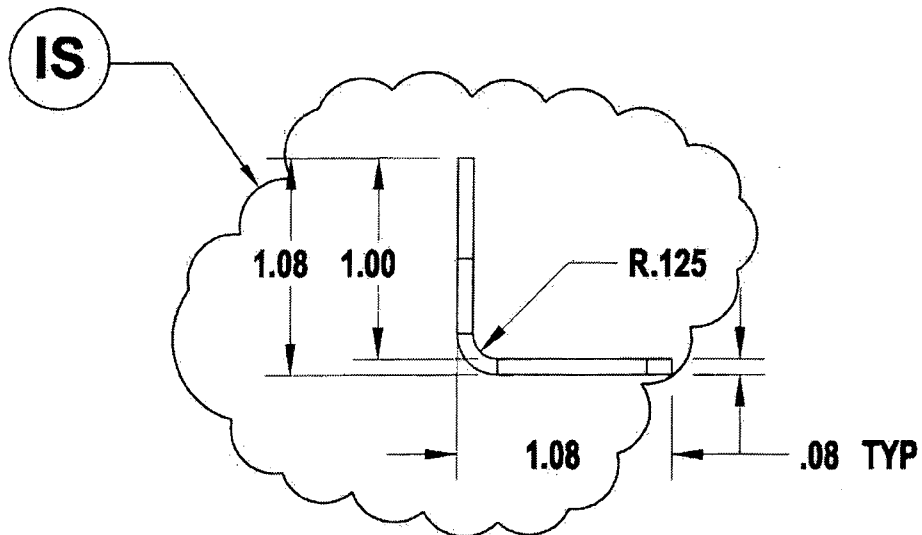
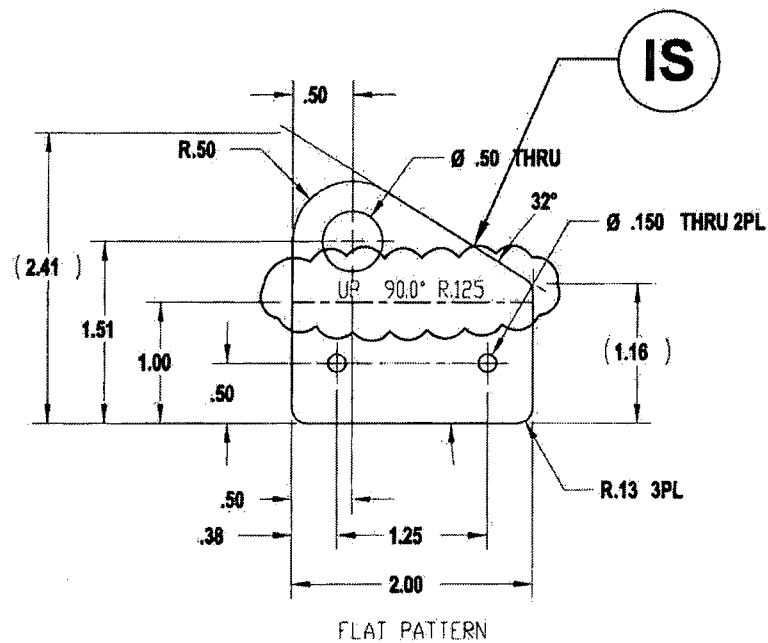
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 120332 mf  
14-b-6

IS



## SHEET 7, ZONE B1 IS:

F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:					CHANGE CATEGORY	DER REVIEW REQUIRED
<input type="checkbox"/> RFMS <input type="checkbox"/> MDL <input type="checkbox"/> INSTALL INSTRU <input type="checkbox"/> ICA <input type="checkbox"/> BDM					<input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR	<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO

**SHEET 7, ZONE C4 IS:****SHEET 7, ZONE D1 IS:****SHEET 7, ZONE B7 IS:**

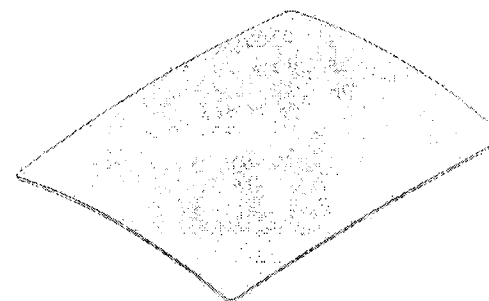
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION
-----	----	-------------	-----	-------------	------------------------

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
1	INCORPORATED ECN(S)		REV 2

# NOTES:

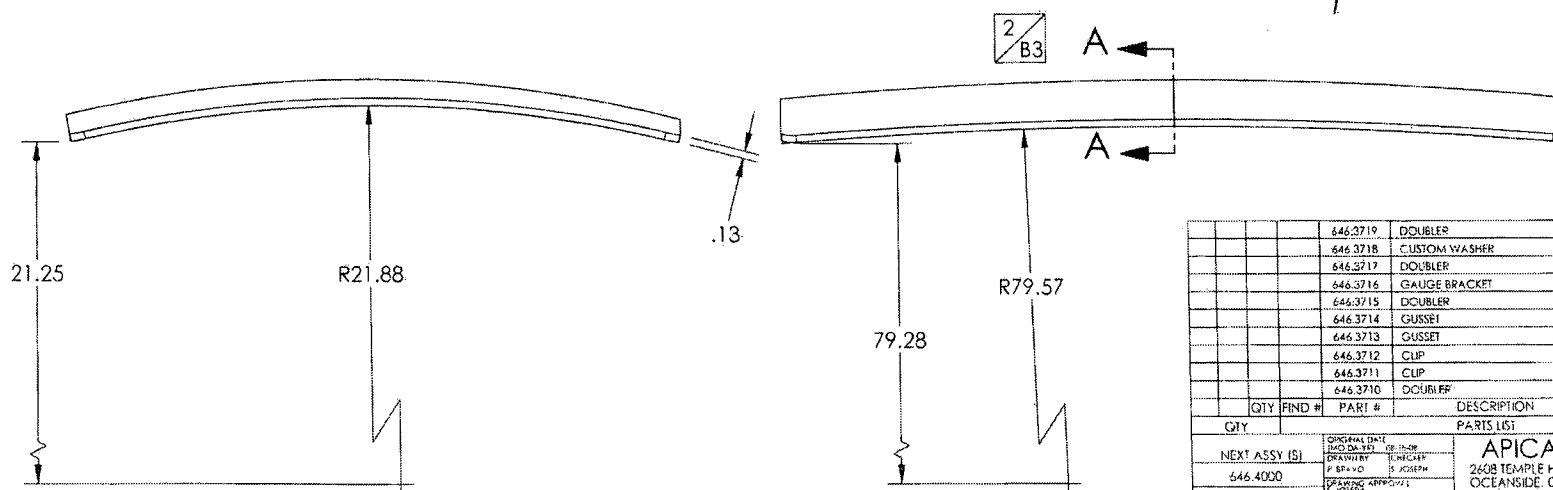
- 1 MATERIAL: ALUMINUM 6061-T6 PER AMS-QQ-A-250/11
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; CARDINAL 4860-50 PRETREATMENT PRIMER PRIME IAW MIL-P-23377J TYPE I CLASS N
- 3 MATERIAL: 17-4 PH AMS 5604, CONDITION H900
- 4 FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N
5. DEBURR AND BREAK ALL SHARP EDGES
6. IDENTIFY IAW MPP-120



646.3710

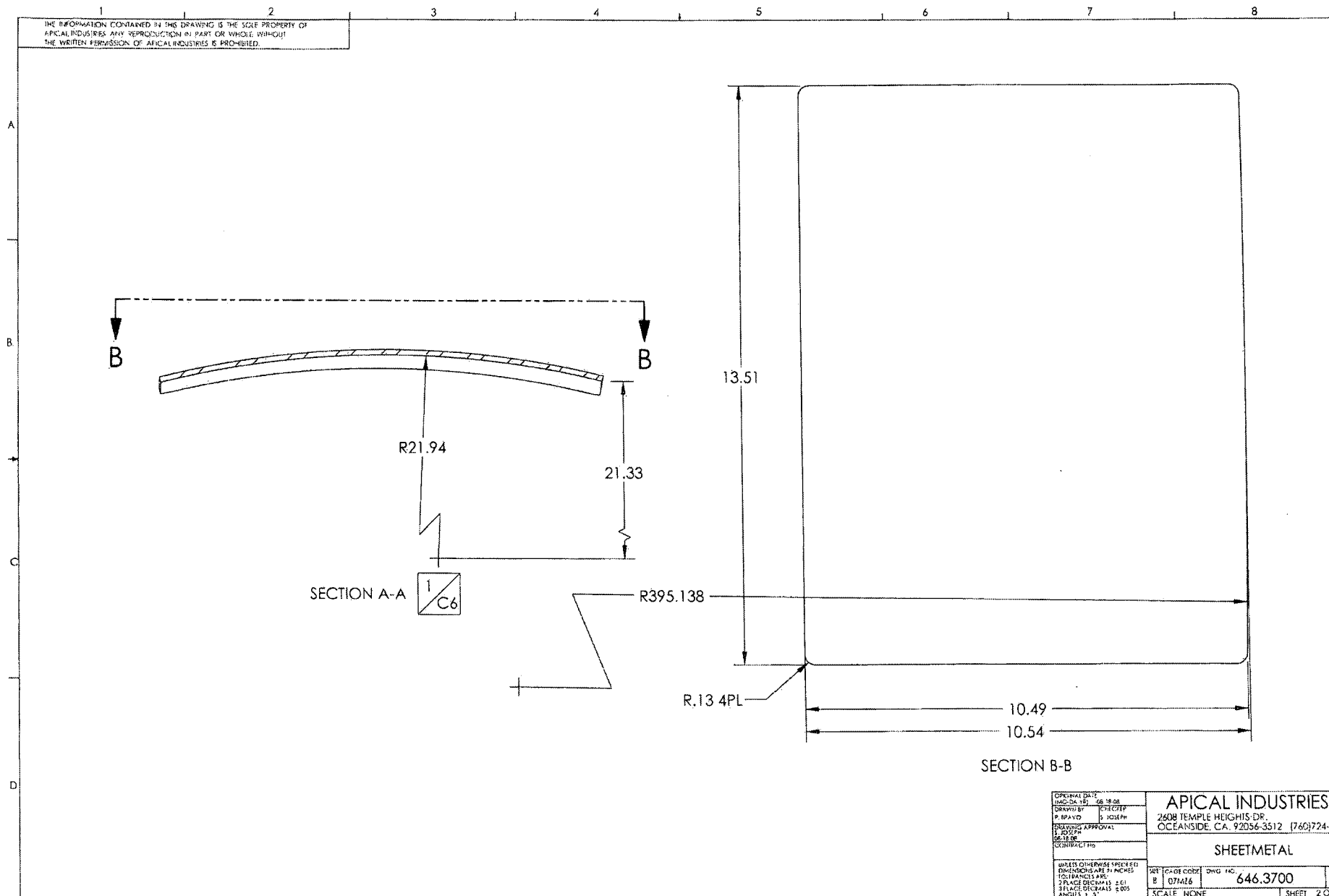
UNINCORPORATED ECN(s)

03702



QTY	FIND #	PART #	DESCRIPTION	MATL	SPEC.
		646.3719	DOUBLER		
		646.3718	CUSTOM WASHER		
		646.3717	DOUBLER		
		646.3716	GAUGE BRACKET		
		646.3715	DOUBLER		
		646.3714	GUSSET		
		646.3713	GUSSET		
		646.3712	CLIP		
		646.3711	CLIP		
		646.3710	DOUBLER		
PARTS LIST			APICAL INDUSTRIES		
NEXT ASSY (S)			2608 TEMPLE HEIGHTS DR.		
646.4000			OCEANSIDE, CA. 92056-3512 (760) 724-5300		
			SHEETMETAL		
			SCALE: NONE		
			SHEET 1 OF 9		

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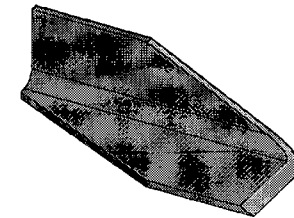
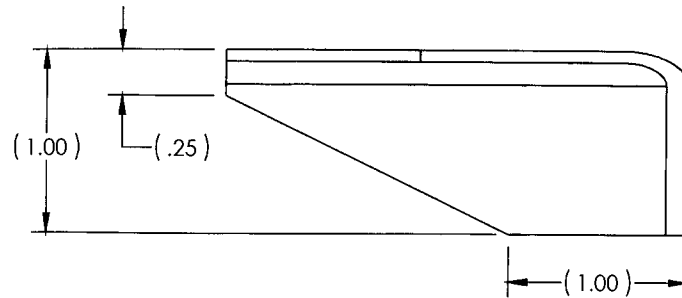


<small>           ORIGINAL DATE: 06-18-08            DRAWN BY: J. JOSEPH            P. SPAYD            DRAWING APPROVAL: J. JOSEPH            06-18-08            CENTRALITY, INC.         </small>		<b>APICAL INDUSTRIES</b> 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
<small>           UNLESS OTHERWISE SPECIFIED            DIMENSIONS ARE IN INCHES            TOLERANCES ARE:            2 PLACE DECIMALS ±.01            3 PLACE DECIMALS ±.005            ANGLES ±.5°         </small>		SHEETMETAL Dwg No. <b>646.3700</b> SCALE: NONE	REV A
SHEET 2 OF 9			

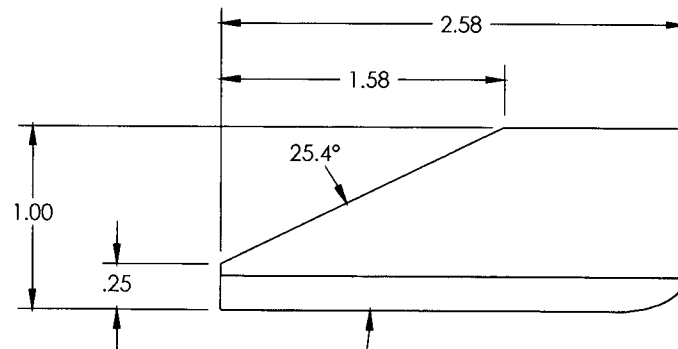
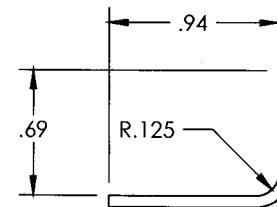
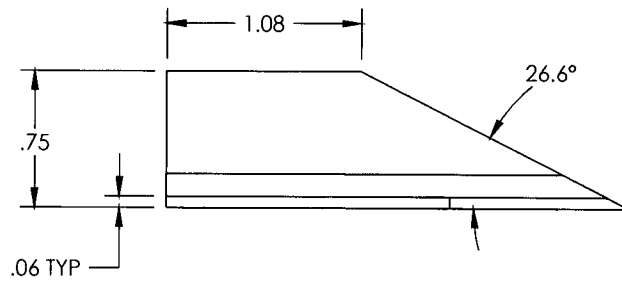


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REV.	DESCRIPTION	DATE	APPROVED



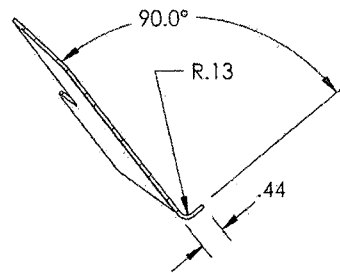
646.3711 SHOWN  
646.3712 OPPOSITE



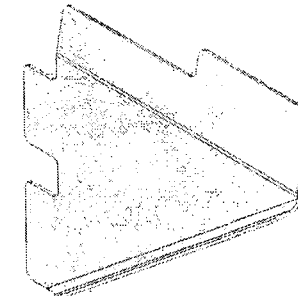
NEXT ASSY (S)		ORIGINAL DATE 08-18-08	<b>APICAL INDUSTRIES</b> 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300  <b>SHEETMETAL</b>	
		DRAWN BY P. BRAVO		
		CHECKED S. JOSEPH		
		DRAWING APPROVAL S. JOSEPH 08-18-08		
		CONTRACT NO.	SITE B CAGE CODE 07M26 DWG. NO. 646.3700 REV. A SCALE: NONE SHEET 3 OF 9	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 ANGLES ±.5°				

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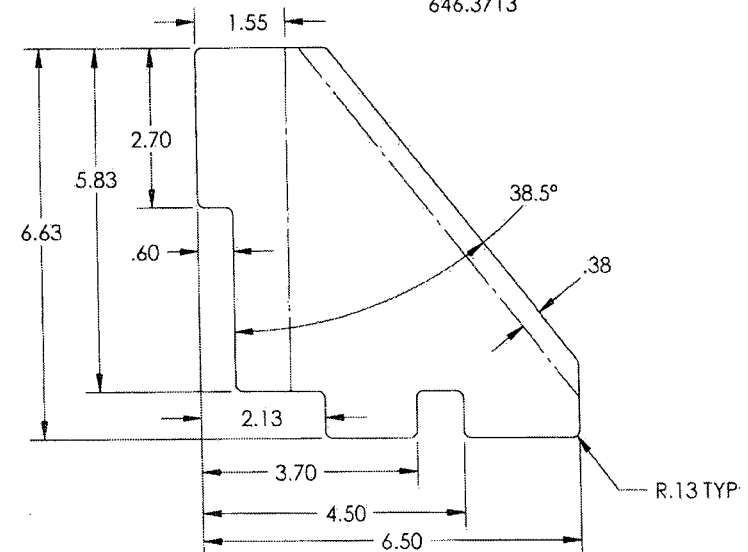
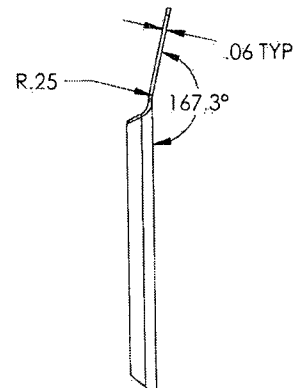
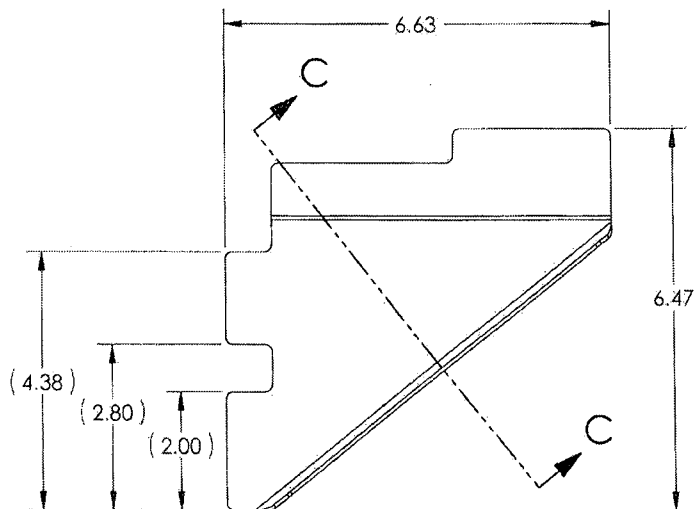
REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



SECTION C-C



646.3713

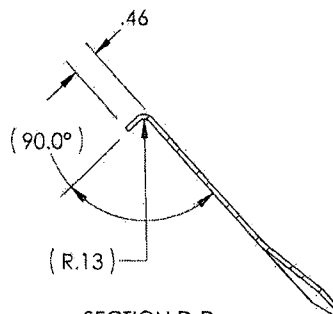
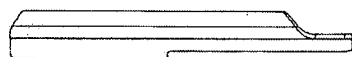


FLAT PATTERN

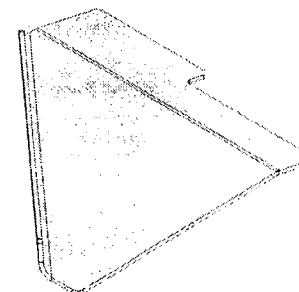
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	DRAWN BY	11/05/08				
	DESIGNED BY	11/05/08				
	CHECKED BY	11/05/08				
	PRESS (OTHERWISE SPECIFIED)		DIE (CAGE CODE)	DWG NO	646.3700	REV
	TOLERANCES ARE FRACTIONS					
	FRACTIONS ARE 1/16"					
	3 PLACE DECIMALS 1/100"					
SCALE: NONE			1 SHEET OF 9			

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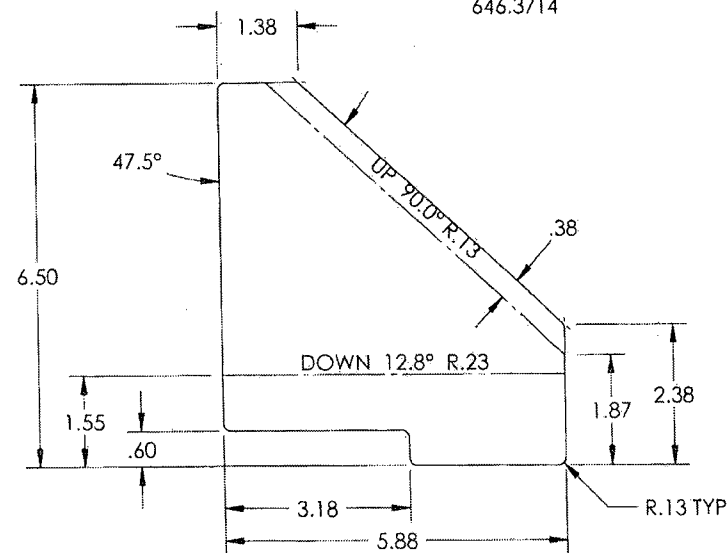
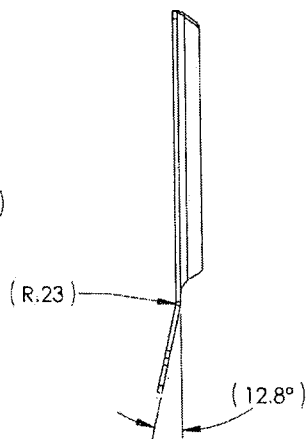
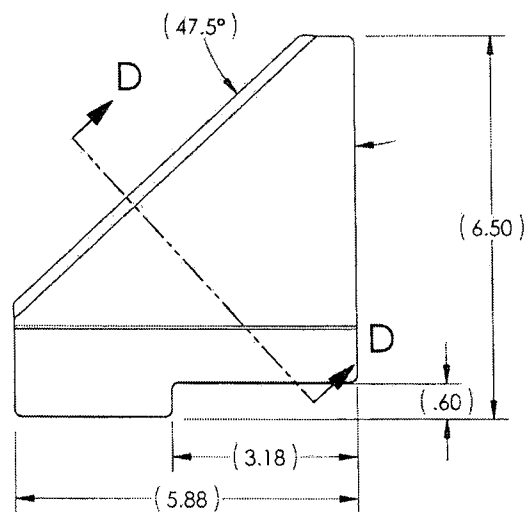
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



SECTION D-D



646.3714

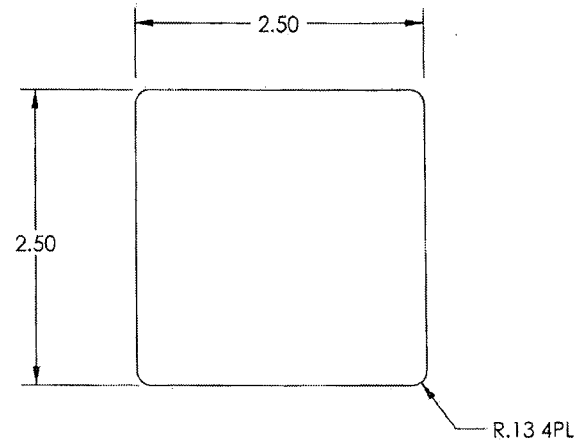


FLAT PATTERN

<small>         ORIGINAL DATE: 02-18-03          DRAWN BY: P. SPANIO          CHECKED BY: J. JOSEPH          DRAWING APPROVAL: J. JOSEPH          DATE: 02-18-03       </small>		<b>APICAL INDUSTRIES</b> 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
<small>         UNLESS OTHERWISE SPECIFIED:          DIMENSIONS ARE IN INCHES          TOLERANCES ARE:          3 PLACE DECIMALS ± .01          2 PLACE DECIMALS ± .005          ANGLES ± 5°       </small>		SHEETMETAL 646.3700	REV. A SHEET 5 OF 9

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED

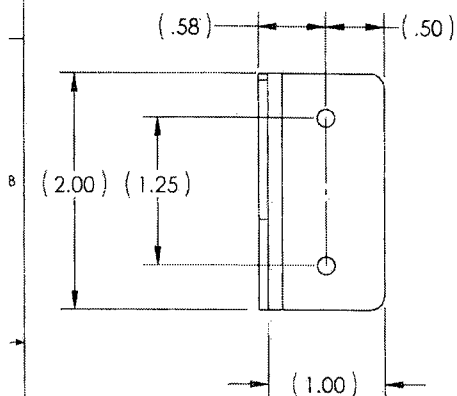


646.3715

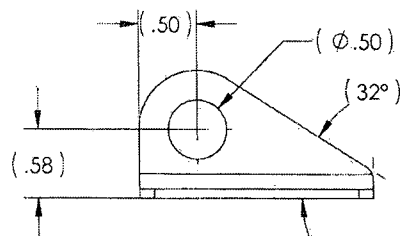
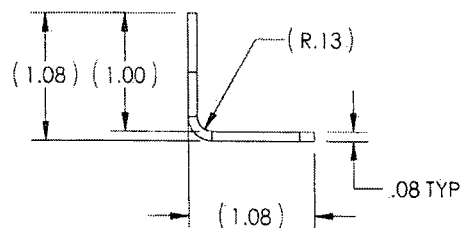
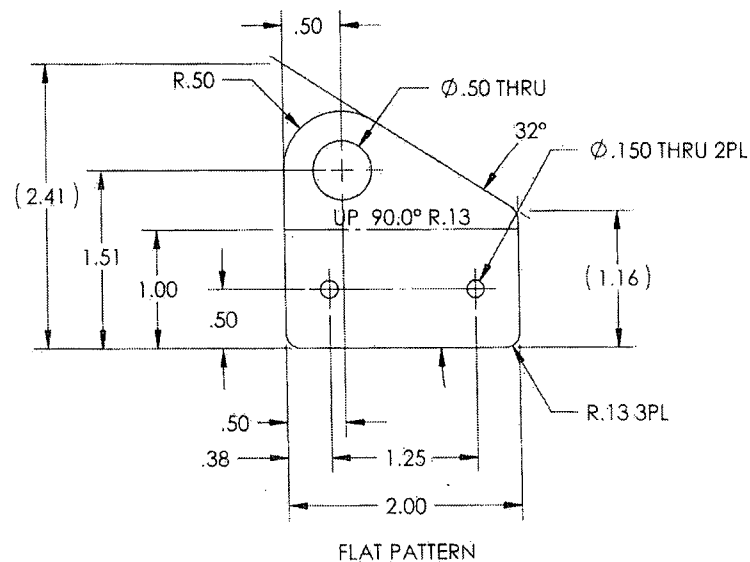
NEXT ASSY (S)	ORIGINAL DATE	08-16-02	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
	DRAWN BY	JOSEPH		
	CHECKED	JOSEPH	SHEETMETAL	
	DATE	08-16-02		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°			VP	CAGE CODE
			B	07M16
			DWG NO	646.3700
			SCALE: NONE	SHEET 8 OF 9

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

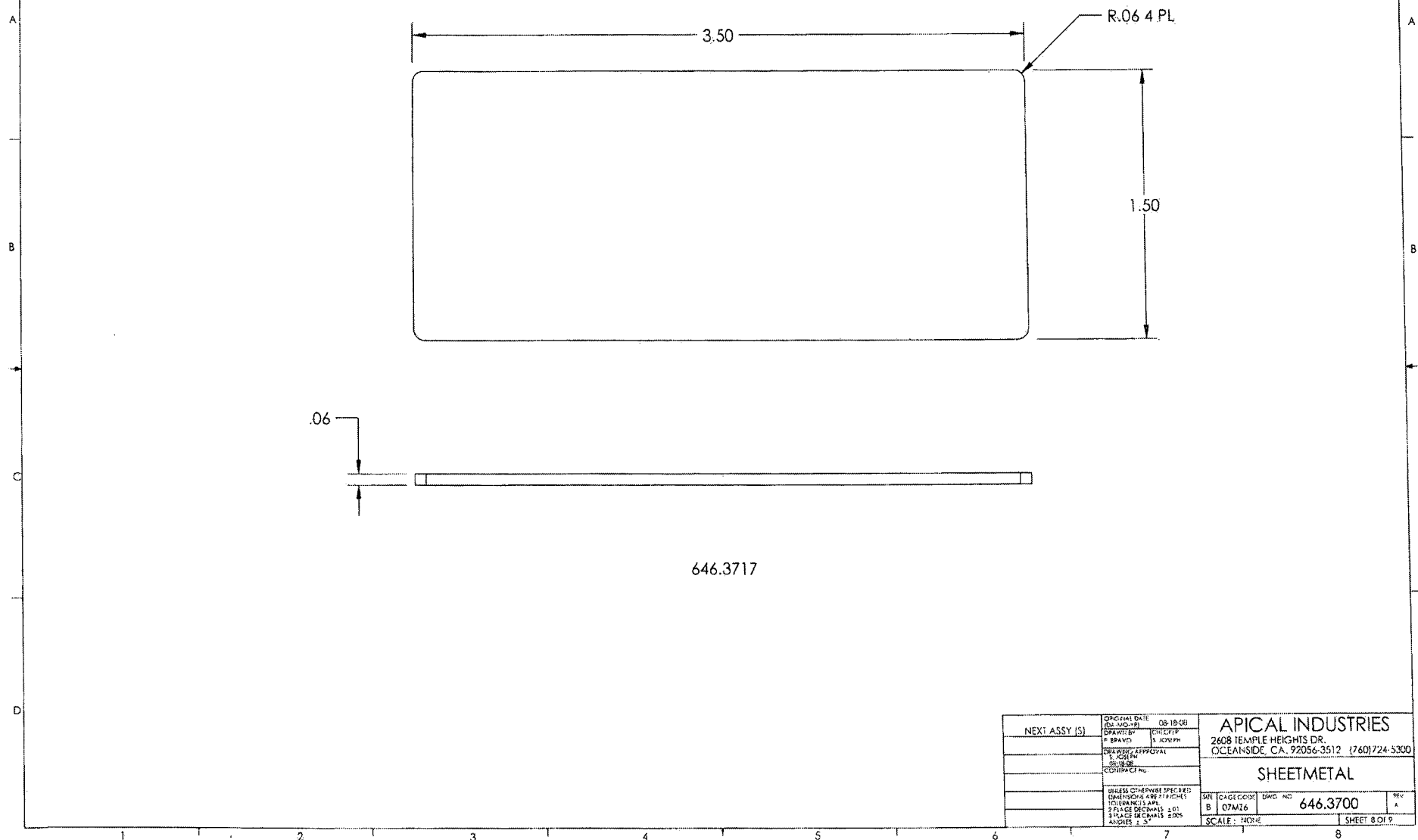


646.3716



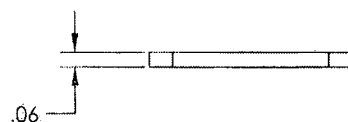
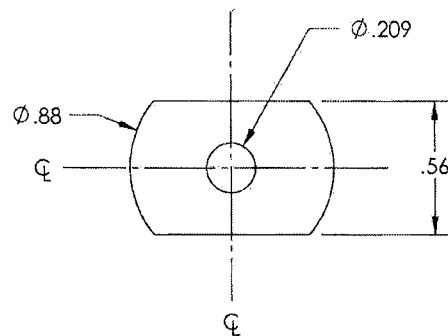
NEXT ASSY (S)	ORIGINAL DATE 08-15-08		APICAL INDUSTRIES	
	DESIGNED BY P. BRAVO		2608 TEMPLE HEIGHTS DR.	
DRAWING APPROVAL	CHECKED BY S. JOSEPH		OCEANSIDE, CA. 92056-3512	
	DATE 08-15-08		(760) 724-5300	
CONTRACT NO.	UNLESS OTHERWISE SPECIFIED		SHEETMETAL	
	DIMENSIONS ARE IN INCHES		DATE 07-26-08	
CONTRACT NO.	TOLERANCES ARE		DWG NO. 646.3700	
	2 PLACE DECIMALS - .01		REV A	
CONTRACT NO.	3 PLACE DECIMALS - .005		SCALE: 1"=1"	
	ANGLES ± .5°		SHEET 2 OF 9	

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

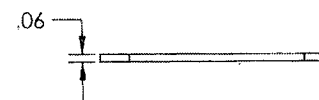
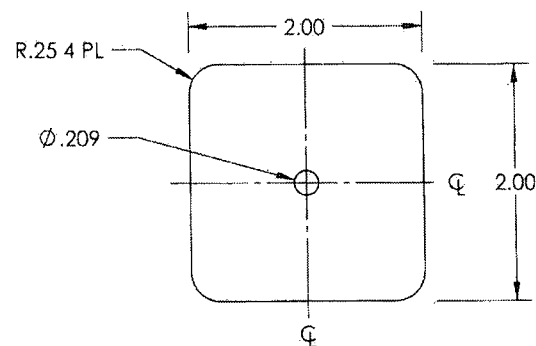


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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



646.3718



646.3719

NEXT ASSY (S)	ORIGINAL DATE	09-18-08	<b>APICAL INDUSTRIES</b> 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
	DESIGNED BY	P. BAYARD		
	PROJECTED BY	S. JOELSON		
	DESIGNING APPROVAL	S. JOELSON		
	CONSTRUCTION		<b>SHEETMETAL</b>  REV. (LACE CODE) DWG. NO. 646.3700 SCALE: NONE SHEET 9 OF 9	
	UNLESS OTHERWISE SPECIFIED			
	DIMENSIONS ARE IN INCHES			
	TOLERANCES ARE:			
	2 PLACE DECIMALS: ±.01			
	3 PLACE DECIMALS: ±.005			
	ANGLES: ± 5°			

**T.P.I. INDUSTRIES INC.**

148 GOODFELLOW  
DELSON, QUÉBEC J5B 1V4  
CANADA  
Tel: (450) 633-0484  
Fax: (450) 633-0879

**Packing Slip**

Packing Slip No.: 6192  
Date: 2014-07-10  
Page: 1

<b>Sold to:</b>	<b>Ship to:</b>
<b>Dart Aerospace</b> Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada	<b>Dart Aerospace</b> Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada
<b>Order No.:</b> 24574	<b>Sold By:</b> JONATHAN LESSARD
<b>Shipped By:</b>	<b>Ship Date:</b> 2014-07-10
<b>Tracking No.:</b>	

Item No.	Unit	Description	Quantity
646.3711	Chaque	646.3711 clip	40
646.3712	Chaque	646.3712 clip	20
646.3712	Chaque	646.3712 clip	40
646.3713	Chaque	646.3713 gusset	40
646.3714	Chaque	646.3714 gusset	40
646.3717	Chaque	646.3717 doubler	30
646.3719	Chaque	646.3719 doubler	20
646.3719	Chaque	646.3719 doubler	40
d2365	Chaque	d2365 wearplate pin	30
d3283-1	Chaque	d3283-1 doubler	40
d3208-3	Chaque	d3208-3 pedal mount angle	20
d3290-1	Chaque	d3290-1 frame	30
d3302-1	Chaque	d3302-1 doubler	10
d3302-3	Chaque	d3302-3 doubler	10
d3363-1	Chaque	d3363-1 console	16
d4072-3	Chaque	d4072-3 airframe hinge backing plate	40
d4073-3	Chaque	d4073-3 door hinge backing plate	50
d4074-5	Chaque	d4074-5 backing plate	40
d4610-5	Chaque	d4610-5 shim	20

**Comment:** Net / 30 from date of invoice 2% svc. chg. on invoices over 30 days





Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO25511**

Purchase Order Date 8/25/2014

PO Print Date 9/2/2014

Page Number 3 of 5

**Order From :**

A.T.G. INDUSTRIES INC.  
731 INDUSTRIELLE ROAD  
ROCKLAND, ON K4K 1T2  
CANADA

VC-ATG001

**Ship To :** DART AEROSPACE LTD  
1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**Contact Name**

**Vendor Phone** 613-446-4544

**Ship To Contact**

**Ship To Phone**

**Ship Via:** VENDOR'S TRUCK

**Ship Acct:**

**Buyer**

Chantal Lavoie

**Customer POID**

**Customer Tax #**

10127-2607

**Terms**

Net 30

**Currency**

CAD

**FOB**

FCA - (Free Carrier)

**Line Total:** \$64.20

6	123781	647.1512 BREAKAWAY TIP	8/27/2014	5.00	\$10.70	\$53.50
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Yes

8/28/2014

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N

**Line Total:** \$53.50

7	120338	646.3719 DOUBLER	8/27/2014	30.00	\$6.25	\$187.50
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Yes

9/5/2014

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N

**Line Total:** \$187.50

8	120634	646.3719 DOUBLER	8/27/2014	30.00	\$6.25	\$187.50
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Yes

8/28/2014

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N

**Note:**

9/2/2014



A.T.G. Industries Inc.  
 731, rue Industrielle Rd.  
 PLATING DEPARTMENT  
 Rockland, On K4K 1T2  
 Canada  
 Ph: (613) 446-4544  
 Fax: (613) 446-4556

## Pack List

Number: 63231

Date: 28-Aug-14

To

DART AEROSPACE LTD  
 1270 ABERDEEN ST.  
 HAWKESBURY, ON K6A 1K7  
 Canada

Ship To

DART AEROSPACE LTD  
 1270 ABERDEEN ST.  
 HAWKESBURY, ON K6A 1K7  
 Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
14 ea	Part: 647.4114 ✓ SHIM HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2  PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20140546 PO: PO25511	Rev:	Line:
6 ea	Part: 647.3913 ✓ BREAKAWAY HARD ANODIZE AS PER MIL-A-8625 TY II, CLASS 2  PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20140547 PO: PO25511	Rev:	Line:
5 ea	Part: 647.1512 ✓ BREAKAWAY HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2  PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20140548 PO: PO25511	Rev:	Line:
30 ea	Part: 646.3719 ✓ DOUBLE HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2  PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20140549 PO: PO25511	Rev:	Line:
30 ea	Part: 646.3719 ✓ DOUBLE HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2  PRIME AS PER MIL-P-23377J TYPE I CLASS N	Rev:	